

Date: Tuesday, 07/04/2009 10:35:14 AM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : PANEL-350 FWD CANOPY |
| Job Number : 47022 | |
| Estimate Number : 13099 | |
| P.O. Number : | Part Number : D36563 |
| This Issue : 07/04/2009 S.O. No. : | Drawing Number : D3656 REV B |
| Prsht Rev. : NC | Project Number : 00204 |
| First Issue : // Type : THERMOFORMING | Drawing Revision : B |
| Previous Run : 44821 | Material : |
| Written By : | Due Date : 24/04/2009 Qty: 4 Um: Each |
| Checked & Approved By : <u>JUD 09.04.07</u> | |
| Comment : Est. Rev. A 07/12/13 New Issue DL verified by:DD Est. Rev. B 08/09/25 Dwg. Update DL | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------------|-------------------------|
| 1.0 | MLEXS093F600607 | GE PLASTICS LEXAN SHEET |
|-----|-----------------|-------------------------|



Comment: Qty.: 34.6600 sf(s)/Unit Total: 138.6400 sf(s)

GE PLASTICS LEXAN SHEET

batch: M 107574

BB 09/04/13

| | | |
|-----|----------------|------------------------------|
| 2.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 09/04/13 X5

| | | |
|-----|---------------|-----------------------|
| 3.0 | THERMOFORMING | THERMOFORMING MACHINE |
|-----|---------------|-----------------------|



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

Dwg. Rev. B

Folio Rev. B

BB 09/04/13 X5

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/04/13 X5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:35:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 FWD CANOPY

Job Number: 47022

Part Number: D36563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Wh. 09/04/15

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

BB 09/04/15

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/15

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/16 (5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST/15 LX

PPA 4/25/14 (5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)
D 08/04/20

Job Completion



U 09.04.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|-----------------------|----------|----------------------|
| DART AEROSPACE LTD | | Work Order: 47022 |
| Description: Panel | | Part Number: D3656-3 |
| Inspection Dwg: D3656 | Rev: A B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Shape Definition | ✓ | | | |
| Free of visual flaws (bumps, cracks, voids, etc.) | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |

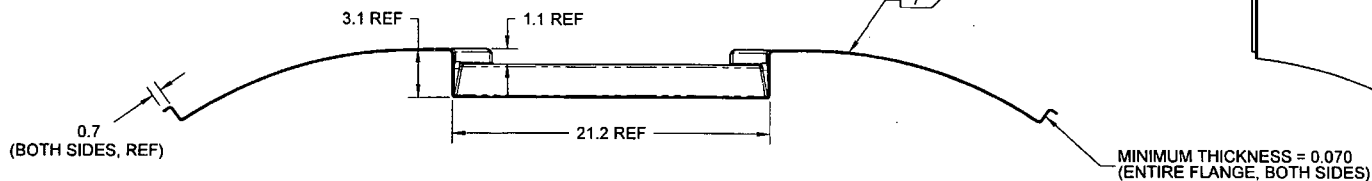
Measured by: BB Date: 09/04/14

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.040 | Min | .046 | ✓ | | | |
| 0.045 | Min | .055 | ✓ | | | |
| 0.050 | Min | .062 | ✓ | | | |
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Measured by: BB Date: 09/04/14
Audited by: Wk Date: 09/04/15
Prototype Approval: N/A Date: N/A

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-----------------|-----------|
| A | 08.05.28 | New Issue | KJ/DL <u>AK</u> | <u>Wk</u> |



TEXTURED SURFACE
ON THIS SIDE

24.7 REF

16.5 REF

57.5 REF

9

MINIMUM THICKNESS = 0.050
(ALL OVER EXCEPT WHERE NOTED)

D3656-1 PANEL

RELEASED
08-07-30 11:10

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022
TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

| | | | |
|------------|--|---|----------|
| B | REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2): REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST | PH | 08.09.18 |
| A | NEW ISSUE | LE | 08.03.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3656 REV. B SHEET 1 OF 2 TITLE PANEL SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.09.18 | | |

NO. 1852
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

